

Date: Thursday, 24/04/2008 10:11:43 AM
 User: COSS Admin

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING PLATE
Job Number	: 38771		
Estimate Number	: 13244		
P.O. Number	:	Part Number	: D3694041
This Issue	: 24/04/2008 S.O. No. :	Drawing Number	: D3694 REVA PRELIM
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11	Drawing Revision	: A PRELIM 08.04.18
Previous Run	: 38474	Material	:
Written By	: <u>SA/08.04.24</u>	Due Date	: 01/05/2008 Qty: 2 Um: Each
Checked & Approved By	:		
Comment	: Est Rev: A 08-03-27 new issue DD verified by: JLM		

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE



Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X12000	6061-T6 Bar 1.0" x 12.0"
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Comment: Qty.: 0.6300 f(s)/Unit Total : 1.2600 f(s)

6061-T6 Bar 1.0" x 12.0"

Batch: 1647191B 8-4-24

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

Cut Blank

A1B 8-4-24

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA731 Rev: A & Dwg D3694 Rev: A

2-Deburr per dwg D3694

3-Tap as per Dwg D3694 for 10-32 Helicoils

SA08/05/03

PTO →

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA08/05/03

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA/08.05.13

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING PLATE

Job Number: 38771

Part Number: D3694041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FD 08/05/06 (2)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FD 08/05/06 (2)

8.0

D36943

MOUNTING PLATE ASSY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

MOUNTING PLATE ASSY

Batch: B 38722

FF 08-05-14 2

9.0

MS21209F120

HELI COIL



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

HELI COIL

Batch: M107823

FF 08-05-14 (2)

10.0

MS24693C69

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

SCREW

Batch: M107737

FF 08-05-14 (2)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install helicoils as per Dwg D3694

2-Install plate as per Dwg D3694

FF 08-05-14 (2)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.06.07

ENGINEERING
APPROVAL

Powder coat grey as per dwg.

* Do not powder coat in threaded holes.

P+O

20/30/20

6.1

start time: 8:20
Temp: 3200

finish time: 8:50

FL

20/30/20

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING PLATE

Job Number: 38771

Part Number: D3694041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

N/A.

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08-06-04 Prototype

Job Completion

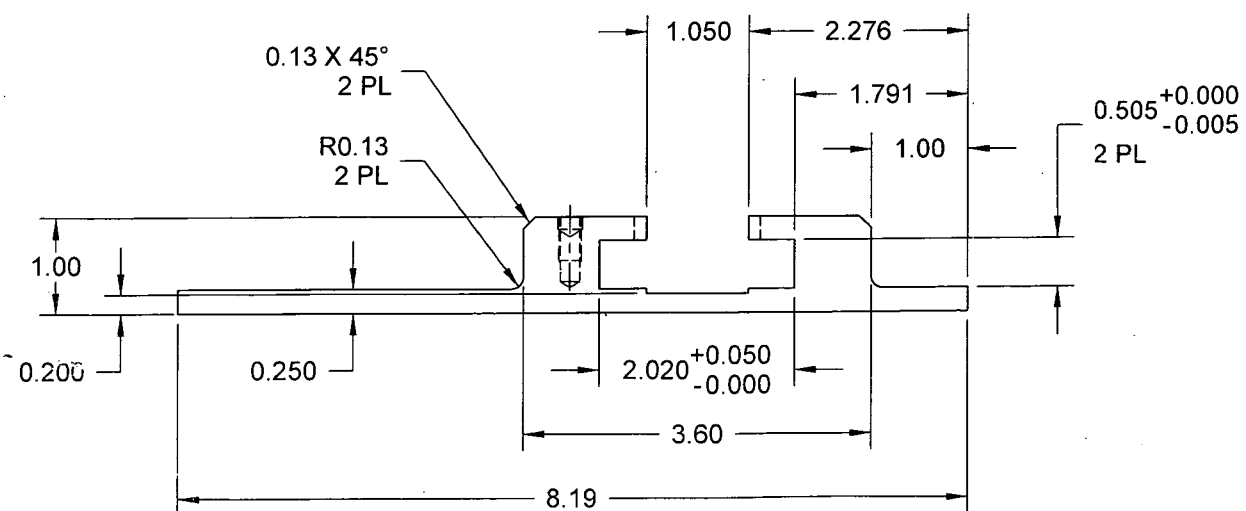
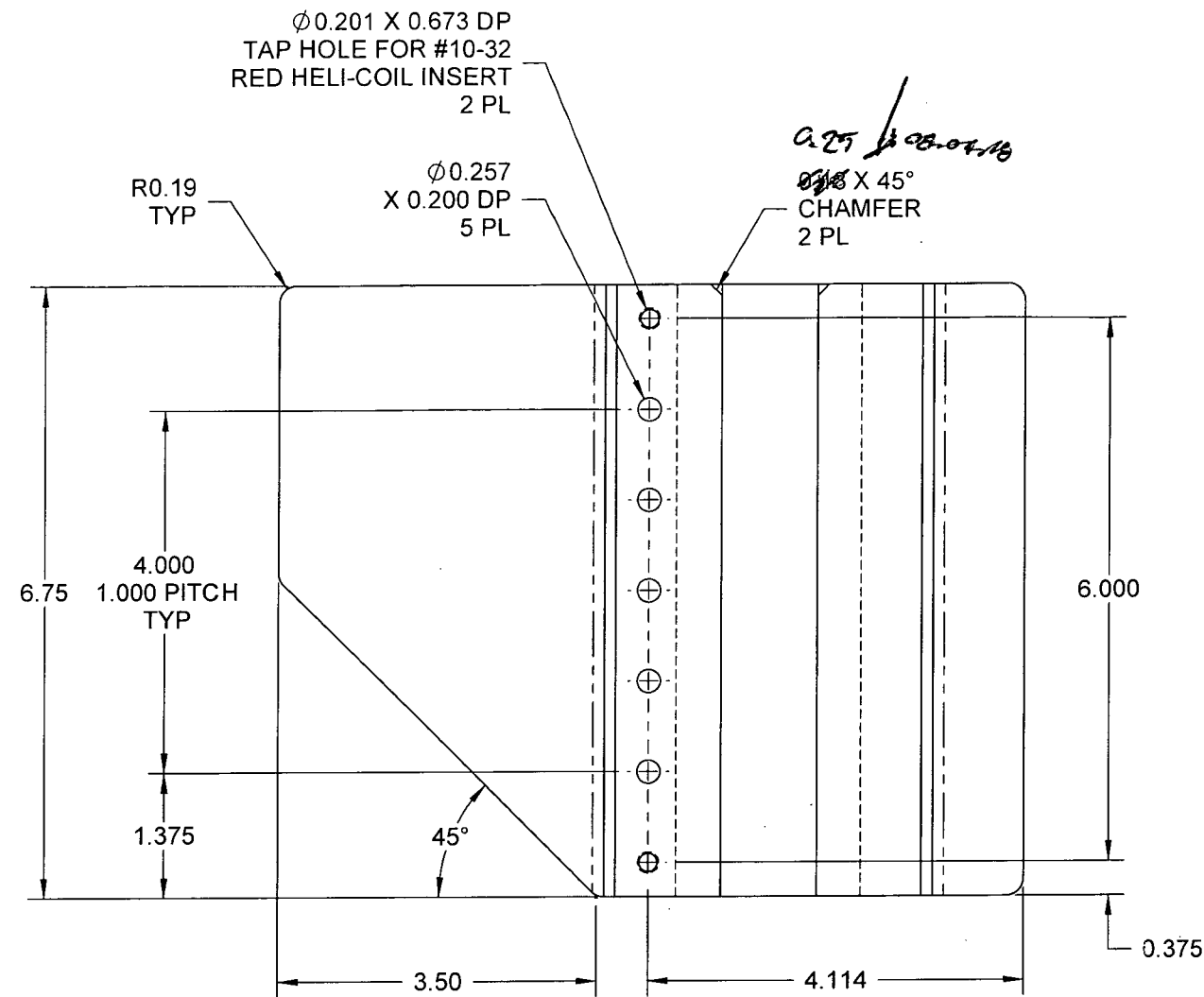


POSITIVE RECALL

EFFECTIVE ~~DATE~~ ~~AUTH~~

RELEASED ~~DATE~~

Charge
to w/o 00224.
mf 08-06-16



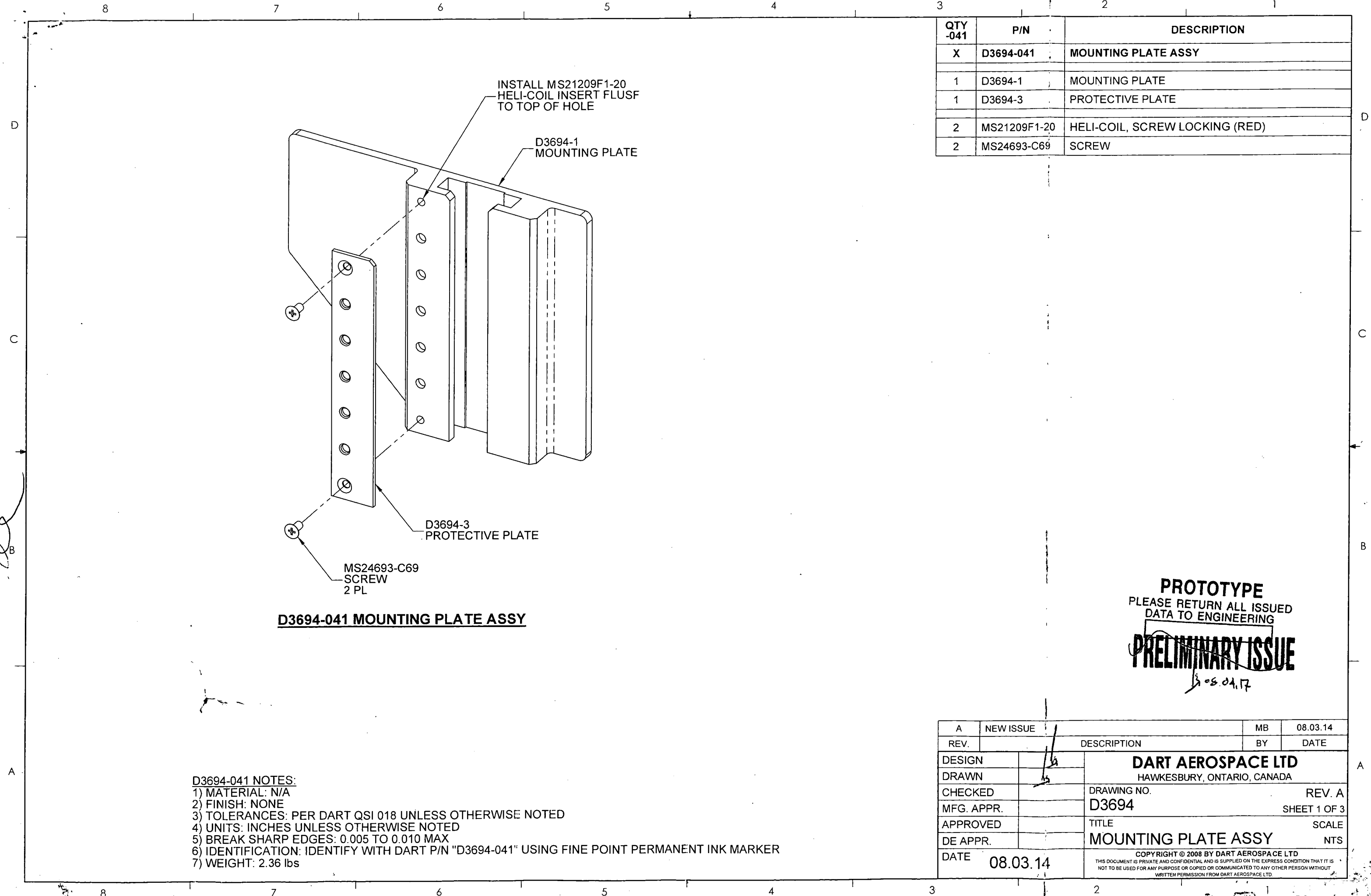
D3694-1 MOUNTING PLATE

1a 731
PROTOTYPE
 PLEASE RETURN ALL ISSUED
 DATA TO ENGINEERING
PRELIMINARY ISSUE
08.04.17

D3694-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 (REF: DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.14 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3694	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
DATE	08.03.14	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



QTY -041	P/N	DESCRIPTION
X	D3694-041	MOUNTING PLATE ASSY
1	D3694-1	MOUNTING PLATE
1	D3694-3	PROTECTIVE PLATE
2	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
2	MS24693-C69	SCREW

D3694-041 MOUNTING PLATE ASSY

- D3694-041 NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3694-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 2.36 lbs

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
PRELIMINARY ISSUE
08.04.17

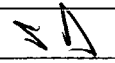
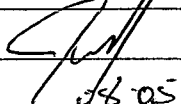

A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3694	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
DATE	08.03.14	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DART AEROSPACE LTD		Work Order: 58771
Description: Mounting plate		Part Number: 3694-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.75	$\pm .030$	6.751	/			
1.375		1.374	/			
1.000 pitch		1.000	/			
3.50	$\pm .030$	3.50	/			
4.114	$\pm .010$	4.113	/			
3.75	$\pm .010$	3.75	/			
6.000	$\pm .010$	6.000	/			
.25 x 45°	$\pm .030$.25 x 45°	/			
Ø.201 x .673	$\pm .006$ $\pm .001$	Ø.202 x .675	/			
Ø.257	$\pm .006$ $\pm .001$	Ø.257	/			
.200 dep		.200	/			
<hr/>						
1.00	$\pm .030$.971	/			
.200	$\pm .016$.198	/			
.250	$\pm .010$.245	/			
8.19	$\pm .030$	8.189	/			
3.60	$\pm .030$	3.604	/			
2.020	$\pm .050$ $\pm .000$	2.025	/			
.505	$\pm .000$ $\pm .005$.503	/			
1.00	$\pm .030$	1.062	/			
1.791	$\pm .010$	1.794	/			
2.276	$\pm .010$	2.279	/			

Measured by: 	Audited by: 	Prototype Approval: 
Date: 08/05/03	Date: 08/05/03	Date: 08/05/03

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Date: Thursday, 24/04/2008 10:11:43 AM
 User: COSS Admin

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : MOUNTING PLATE

Job Number : 38771

Estimate Number : 13244

P.O. Number :

Part Number : D3694041

This Issue : 24/04/2008

S.O. No. :

Drawing Number : D3694 REVA PRELIM

Prsht Rev. : NC

Project Number : N/A

First Issue : 11

Type : MACHINED PARTS

Drawing Revision : A PRELIM

Previous Run : 38474

Material :

Due Date :

: 01/05/2008

Qty: 2 Um: Each

Written By :

Checked & Approved By :

Comment : Est Rev: A 08-03-27 new issue DD verified by: JLM

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE



Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

M6061T6B1000X12000

6061-T6 Bar 1.0" x 12.0"



Copper + Brass



Comment: Qty.: 0.6300 f(s)/Unit Total: 1.2600 f(s)

6061-T6 Bar 1.0" x 12.0"

Batch: 104719

IB 8-4-24

7/0: 3300

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

Cut Blank

A
A

IB 8-4-24

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA731 Rev. A & Dwg D3694 Rev. A

2-Deburr per dwg D3694

3-Tap as per Dwg D3694 for 10-32 Helicoils

SA

08/05/03

PTO

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA

08/05/03

QC8

SECOND CHECK



CHECK

Date: 7/6/13Batch No: M154719Supplier: COPPER BRASSDart P/O: 3300
 Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

 Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC8 Inspection ☒ EC 0266113 N/A ☐
 Work Order ☐ N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date

Received/Costing

Initial

07/06/14
K.P. 4845

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

OUR SALES DEPT. HAS NEW OFFICE HOURS
 7:30 AM TO 5:00 PM - MONDAY TO FRIDAY
 *** CUSTOMER PICK-UP HOURS ***
 *** 9:00 AM TO 4:00 PM ***
 PLEASE NOTE OUR NEW GST # 140223934
 EFFECTIVE MARCH 20, 2006

ALUMINUM • BRASS • COPPER • PLASTICS • STAINLESS

Material	Processing	Freight	Other	Taxes	TOTAL DUE
483.84				29.03	512.87

Taxes: GSTSAL 29.03 0.00

GST# R140223934



ALCOA EXTRUSIONS, INC.
MORRIS OPERATIONS
4920 NORTH TABLER ROAD
MORRIS, IL
60450-0913

Alcoa Extrusions, Inc. a subsidiary of Alcoa Inc

Invoice To Customer

THYSSENKRUPP MATERIALS NA INC
2821 LANGSTAFF ROAD
ATIN: ACCOUNT PAYABLE

CONCORD, ON - L4K-1A1
Ship To Customer

THYSSENKRUPP MATERIALS NA INC
2821 LANGSTAFF ROAD

CONCORD, ON - L4K5C6

Certified Inspection Report

Sales Order Number
4606389 Line No. 10

Customer P/O
PEC-66256-8

Cert Number	Page
AEF1107325	1 of 1
Cert Creation Date	Cert Print Date
10-MAY-07	10-MAY-07

Quantity Shipped	Date Shipped	Item Description
1506 LB	10-MAY-07	Extruded Econ-o-Plate
B/L	Item No.	1.000 TK x 12.000 W
1233111	G03279577	SECT 505054
Delivery ID	Item No. Rev	144.5 IN LN
2236571	—	60617.T6511
Customer Part No		FIN M-MILL
505054		WT 14.112 F 2 CS 12.1
		Marking SPOT MARKED:
		ASTMB221 REV 06
		ASMESH221 REV
		UNSHA960G1 REV

Legal Statement

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material met the composition and had the mechanical properties shown on the face of this certification. Also, note that mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product. This certification is not to be reproduced in partial form without prior written approval of our Quality Assurance Dept.

Signature And Title

Juan L. Arciniega
Juan L. Arciniega
Quality Assurance Manager
10-MAY-07

Quantities per Lot / Packages

Package Number	Lot Number	Quantity	UOM	Weight	
				Gross	Net
G11 PKG126238	7228715	6	PCS	1044	1014
G11 PKG126239	7228715	3	PCS	522	492

Mechanical Property - Test Limits

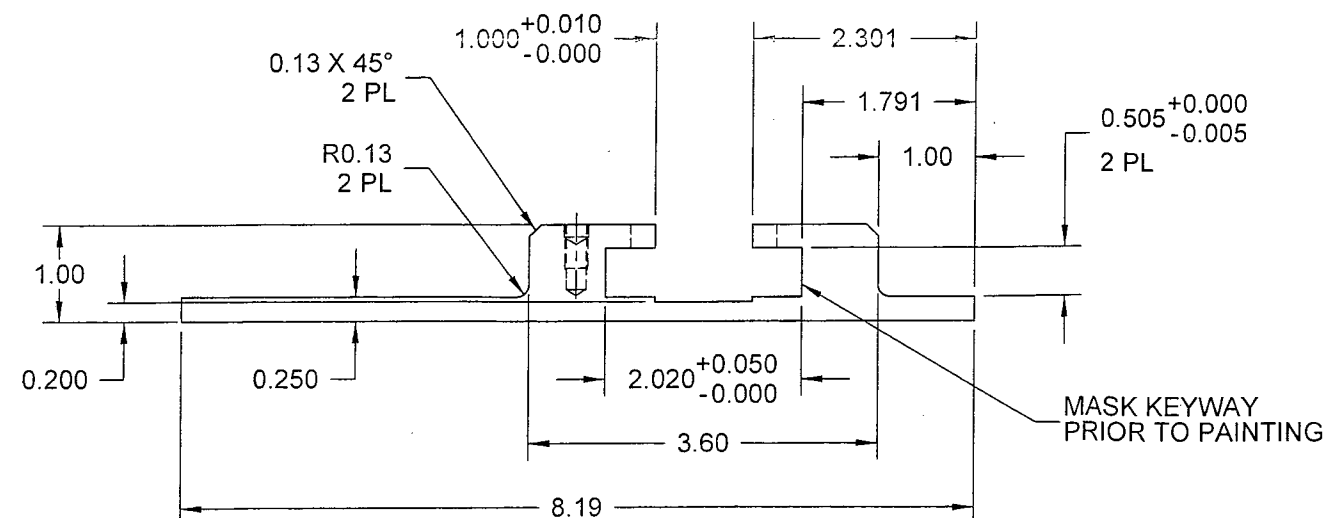
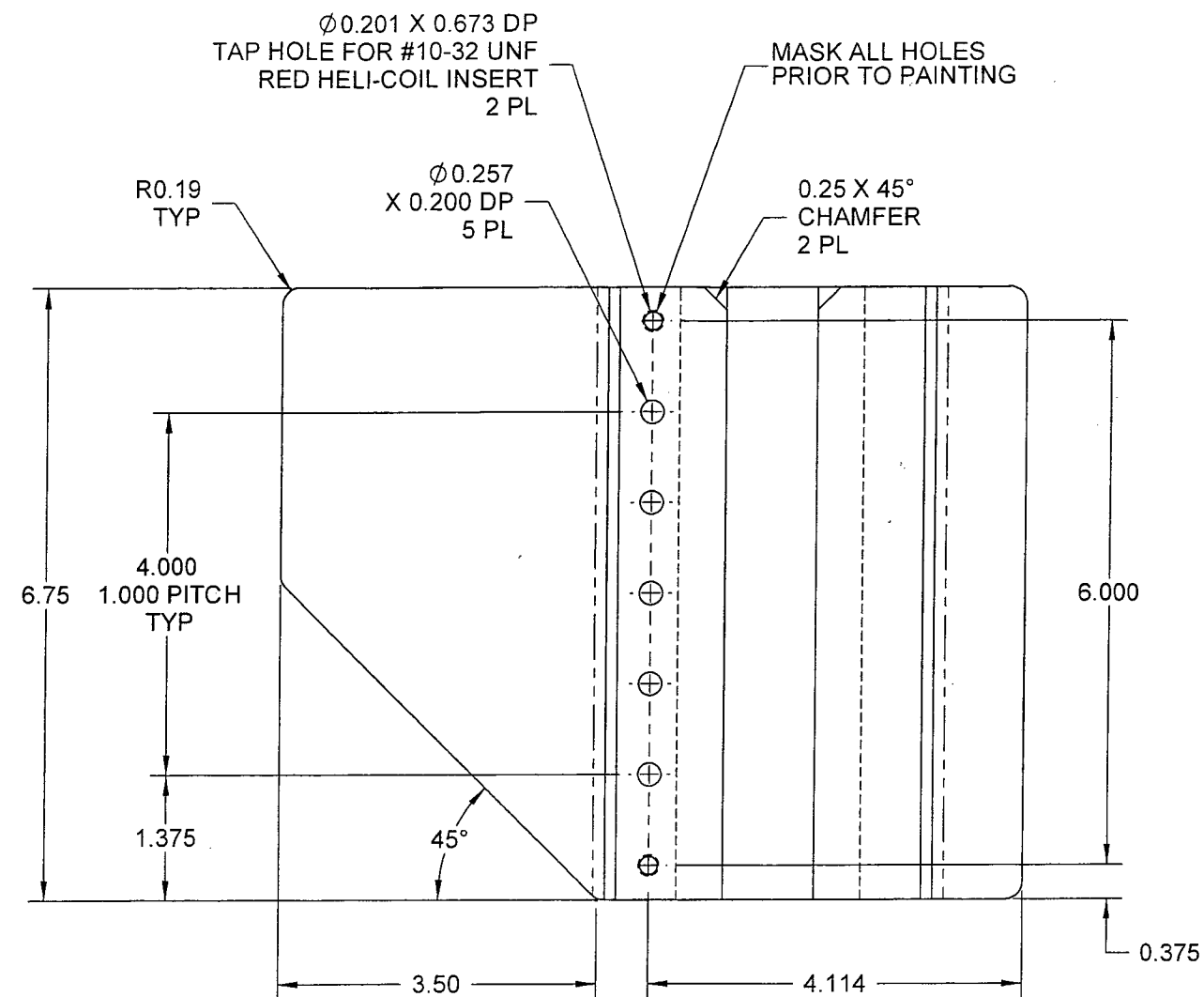
Test Type			UTS - L		TYS - L		EL 4D-Long	
UOM			KSI		KSI		PCT	
# of Tests			—		—		—	
Test Temper	Lot Number	# of Tests	Min	Max	Min	Max	Min	Max
T6511	7228715	2	41.7	43.4	36.5	37.3	16.8	19.5

Cert Notes

Made in USA

We certify that this is a true copy of the report furnished by the producer of the material, or data resulting from tests performed in approved labs.

UNFILTERED RECORD COPY 0061 T6511
12.00" X 14.00" X .001"
ART NO.



D3694-1 MOUNTING PLATE

PRELIMINARY ISSUE
208 08.07

D3694-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.15 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3694	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
DATE	08.06.26	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	